



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-145
Job Sheet 195709



Part No: D205-634-145

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D2580-049 REV H, IIN-D205-634 REV I IPP REV:B 14.04.21 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Skidtubes - 1	1 pcs	7/5/19	7/5/19	0.00	0.33	Skidtubes - 1	
							Skidtubes - 2	
							Skidtubes - 3	<i>mlb</i>
							Skidtubes - 4	
							Skidtubes - 5	
							Skidtubes - 6	
							Skidtubes - 7	
120	Skidtubes - Bend - 2 - B4B	1 pcs	7/5/19	7/5/19	0.00	2.00	Skidtubes - Bend - B4B	<i>mlb</i>
130	Skidtubes - 2 - B4B	1 pcs	7/5/19	7/5/19	0.00	2.00	Skidtubes - 1 - B4B	
							Skidtubes - 2 - B4B	
							Skidtubes - 3 - B4B	<i>mlb</i>
							Skidtubes - 4 - B4B	
							Skidtubes - 5 - B4B	
							Skidtubes - 6 - B4B	
							Skidtubes - 7 - B4B	
140	QC 5	1 pcs	7/5/19	7/5/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	<i>BE</i>
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	



Dart Aerospace Ltd.
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CANADA
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Container No: S187770



Part: D205-634-145

Job No: 195709

Serial No/Batch: S187770

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 2, FAA STC SR005631

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				QC 5 - 40	
150 Skid tubes - 3 - B4B	1 pcs	7/5/19	0.00 1.00	Skid tubes - 1 - B4B	
				Skid tubes - 2 - B4B	
				Skid tubes - 3 - B4B	
				Skid tubes - 4 - B4B	
				Skid tubes - 5 - B4B	
				Skid tubes - 6 - B4B	
				Skid tubes - 7 - B4B	
160 QC 10	1 pcs	7/5/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
170 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS
				QC 5 - 3	24
				QC 5 - 43	9-89
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.50	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
190 Powdercoat - 1 White Gl(A)-B4B	1 pcs	7/5/19	0.00 1.00	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
200 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	

BE
JW

JUN 13 2019

JUN 13 2019

JUN 13 2019

BE 19-6-26

BE 19-06-26

DAS
59
9-89

			QC 3 - 43		
			QC 3 - 24		
210 Handfinish - 3-1- WingWalk-B4B 1 pcs	7/5/19	0.00 2.00	Handfinish - 3 - 1 - B4B		BER 19-08-26
			Handfinish - 3 - 2 - B4B		
			Handfinish - 3 - 3 - B4B		
			Handfinish - 3 - 4 - B4B		
			Handfinish - 3 - 5 - B4B		
220 QC 5 1 pcs	7/5/19	0.00 0.00	QC 5 - 10		DAG 40 AUG 26 2019 9-89
			QC 5 - 12		
			QC 5 - 17		
			QC 5 - 18		
			QC 5 - 19		
			QC 5 - 22		
			QC 5 - 24		
			QC 5 - 3		
			QC 5 - 43		
			QC 5 - 49		
			QC 5 - 51		
			QC 5 - 58		
			QC 5 - 68		
			QC 5 - 9		
			QC 5 - 50		
			QC 5 - 30		
			QC 5 - 40		
230 Packaging 3-1 - Stock - B4B 1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B		Max B
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		
			Packaging 3 - 28 - B4B		
			Packaging 3 - 29 - B4B		
			Packaging 3 - 30 - B4B		
			Packaging 3 - 31 - B4B		
			Packaging 3 - 32 - B4B		
			Packaging 3 - 33 - B4B		
			Packaging 3 - 34 - B4B		
			Packaging 3 - 35 - B4B		
			Plex 5/30/19 9:03 AM Dart.Guerin.Kimberley		

235 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 36 - B4B	DAS
				DC - 1 - B4B	21
240 QC 21 - FG	1 pcs	7/5/19	0.00 0.00	DC - 2 - B4B	9-89 SEP 09 2019
				QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-89 SEP 09 2019

Part Op 110 - (Skidtubes)1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL
Descriptions: 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - (CNC Delta 100 Bender)1-Bend as per program D2580 SKID on CNC Bender and Folio FT 16 2-Cut tubes as per Dwg. D2580 3- Scribe batch# in aft end of tube

130 - (Skidtubes)1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Skidtubes)1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 139011 - Grind welds flush. 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

160 - (QC10- Inspect visual per QSI004- ground welds)

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)Realodine tube as per QSI 005

190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME:

200 - (QC3- Inspect Part Finish)

210 - (Assemble as per dwg)1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 5163437 Sikaflex expire date: 19/09. 2-Coat D2594-3 O' rings with

220 - (QC5- Inspect part completeness to step on W/O)Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

230 - (Identify as per dwg & Stock Location: _____)Identify and pack for shipping as per PPPD205-634-145 Location : FG073

235 - (Document Control)Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

240 - (QC21- Final Inspection - Work Order Release)

wing walk 3185147 E

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - 1	5170507
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	150-Skidtubes - 3 - B4B	5177096
D4202-1	Spacer	24 pcs (24 ea)	150-Skidtubes - 3 - B4B	5100792
AN3-5A	Bolt	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5149156-1
AN4-45A	Bolt	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5103295-2
D2570	Bushing	16 pcs (16 ea)	210-Handfinish - 3-1- WingWalk-B4B	5144295-2
D2594-1	Plug	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5189025
D2594-3	O-Ring	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5173297
D2855	Cap	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5126188
D5061-1	Fwd Wearplate	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5140887
D5061-3	Aft Wearplate	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5203397
MS21042-4	Nut	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5089336
NAS1149D0332J	Washer	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5178378

m.u. 010637

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2580-1	1	4	0
150-Skidtubes - 3 - B4B	D2576-3	1	47	0
	D4202-1	24	857	0
210-Handfinish - 3-1- WingWalk-B4B	AN3-5A	2	194	0
	AN4-45A	8	53	0
	D2570	16	85	0
	D2594-1	8	106	0
	D2594-3	8	411	0
	D2855	1	52	0
	D5061-1	1	3	0
	D5061-3	1	1	0
	MS21042-4	8	116	0
	NAS1149D0332J	2	3,596	0

Part Specifications	
Specifications could not be found.	

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ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2690-041	SKIDTUBE ASSEMBLY
2		X			D2690-045	SKIDTUBE ASSEMBLY
3			X		D2690-047	SKIDTUBE ASSEMBLY
4				X	D2690-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2690-1180	EXTRUSION
21			18	16	D2670	BUBBLING
22	1	1	1	1	D2678-3	STEP
23					D2679	SPACER
24	16	16	8	8	D2694-1	PLUG
25	16	16	6	6	D2694-3	O-RING
26	1	1	1	1	D2696	208 WEB
27	1	1	1	1	D2695	AFT CAP
28	1	1			D3694-5	WEARSHOE
29	1	1			D3694-6	WEARSHOE
30	1	1			D3694-11	WEARSHOE
31	1	1			D3694-13	WEARSHOE
32	20	20	24	24	D4002-1	SPACER
33			1		D4005-041	WEARPLATE ASSEMBLY
34			1		D4009-043	WEARPLATE ASSEMBLY
35				1	D6001-1	FWD WEARPLATE
36				1	D6001-3	AFT WEARPLATE
60	60	60			AL37-1032-130 or AK57-1032-130 or AK54-1032-130 or AEL5-1032-130	INSERT
81	50	50			AN504A	BOLT
82	2	2	2	2	AN50-5A	BOLT
83			6	6	AN4-45A	BOLT
84	50	50			NAS1146D0352R	WASHER (AN600D10L)
85	2	2	2	2	NAS1146D0352J	WASHER (AN600D10L)
86			6	6	MS21042-4	NUT (CR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: NA
- 2) FINISH: CHEMICAL CONVERSION PER DART Q81 008 4.1 PRIOR TO INSERTING D2690 WEB POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART Q81 008 4.3 BLACK ANTI-SKID PART AS INDICATED PER DART Q81 008 4.4.
- 3) TOLERANCES ARE PER DART Q81 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2690-041 = 33.7 lbs
D2690-045 = 46.1 lbs
D2690-047 = 46.1 lbs
D2690-049 = 32.0 lbs
- 8) WELDING PER DART Q81 004.
- 9) INSERT D2690 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-941 ADHESIVE PER DART Q81 016 BEFORE BONDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE D78217 & D78697 ONLY FOR D2690-041/-045 TO LOCATE AND DRILL 20.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (80 PLACES) AFTER FINISH. INSTALL AN504A BOLTS AND NAS1146D0352R WASHERS WITH SIKAFLEX-3411-291.
- 12) INSERT D2694-1 PLUG CW D2694-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2690-041/-045 AND 8 PLACES FOR D2690-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2690 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION



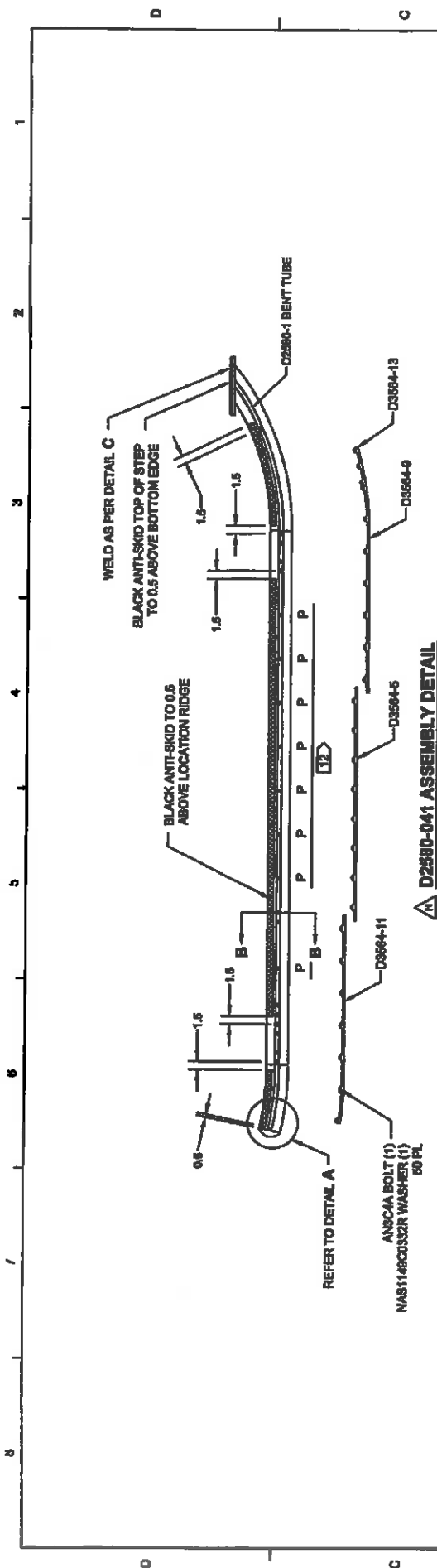
H	SHEET: PL DELETE D2690-145-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -045, -047 WEIGHT UPDATED PER DSI 8508	AS	14.04.09
F	INCORPORATE DED D2690-E-1 PER PART 2-218	DC	13.06.20
E	ADD D2690-047 (2N C4-7) AND D2690-7 (2N BS-9); INCLUDED DED D2690-0-1; REFORMATTED DRAWING TO CURRENT STANDARDS; D78217 & D78697 WAS TD2577-205 (2N C4-1)	RF	11.08.21
D	CHANGE TO 88 WEARPLATES AND GASKETS.	PH	07.04.06
C	INCLUDE DED 9124/ 9193	CP	06.08.26
B	REDRAWN, INCLUDED DED 00N4/ 0097	DS	06.12.02
A	AS MANUFACTURED	DS	06.02.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	REV. H		
INFO. APPR.	DRAWING NO. D2690		
APPROVED	TITLE 208 SKIDTUBE ASSEMBLY		
DE APPR.	SCALE		
DATE	17.06.09		

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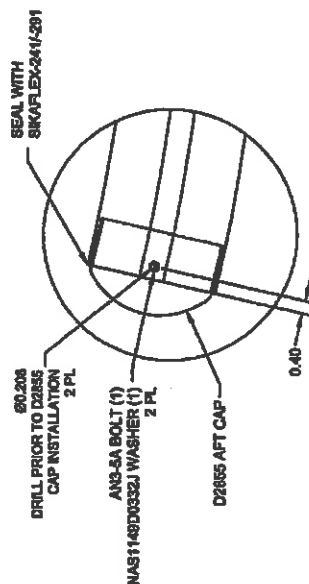
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HAMMERSLEY, ONTARIO, CANADA

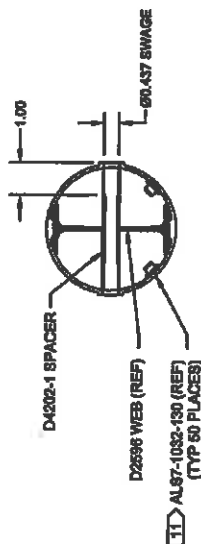
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DETAIL A
SCALE 6X



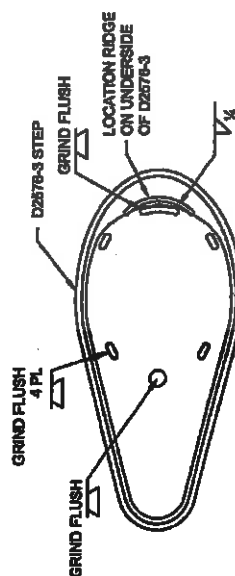
SECTION B-B
SCALE 5X



**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. INSERT D402-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

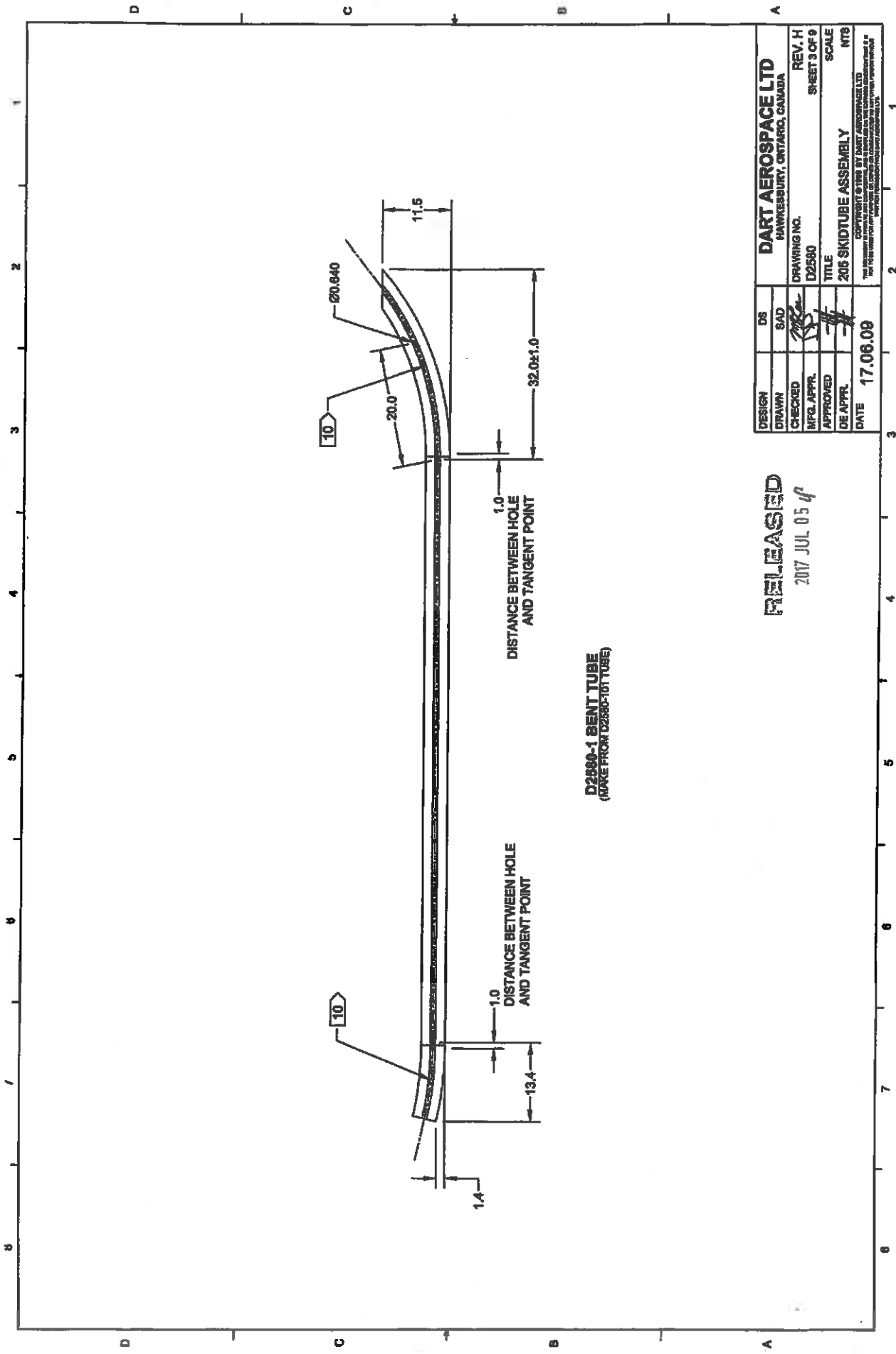
DETAIL C
SCALE 5X



DESIGN	DS	DART AEROSPACE LTD HARRISBURY, ONTARIO, CANADA DRAWING NO. D2650 REV. H SHEET 2 OF 9 SCALE 1:1 DATE 17.06.09
DRAWN	SAD	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DATE	17.06.09	205 SKIDTUBE ASSEMBLY NTS COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DRAWING IS UNCLASSIFIED AND NOT FOR DISSEMINATION OUTSIDE THE DEFENSE AND SECURITY ESTABLISHMENTS, AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL,

RELEASED

2017 JUL 05

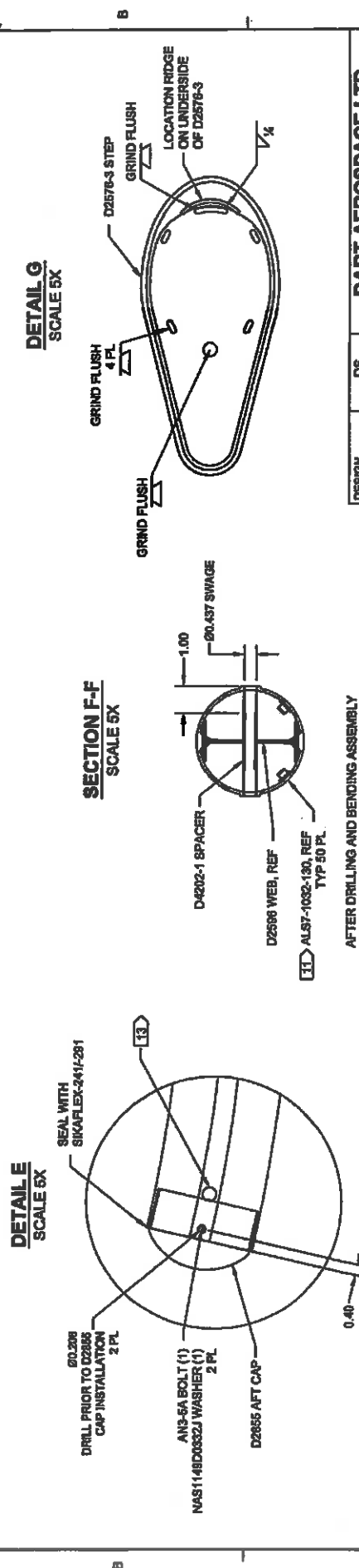
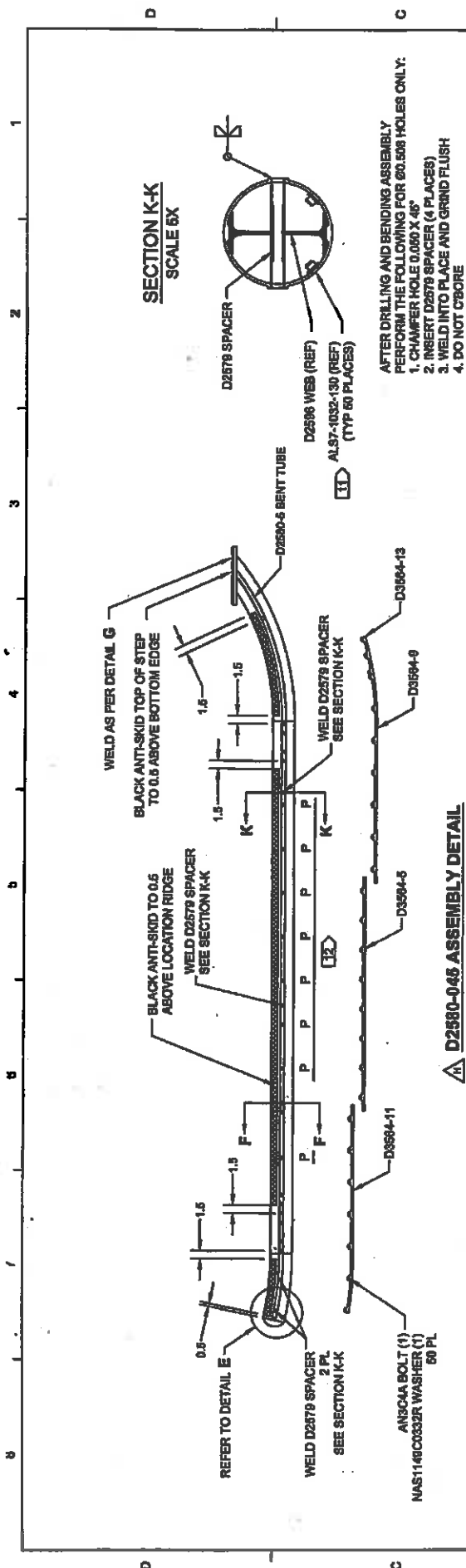


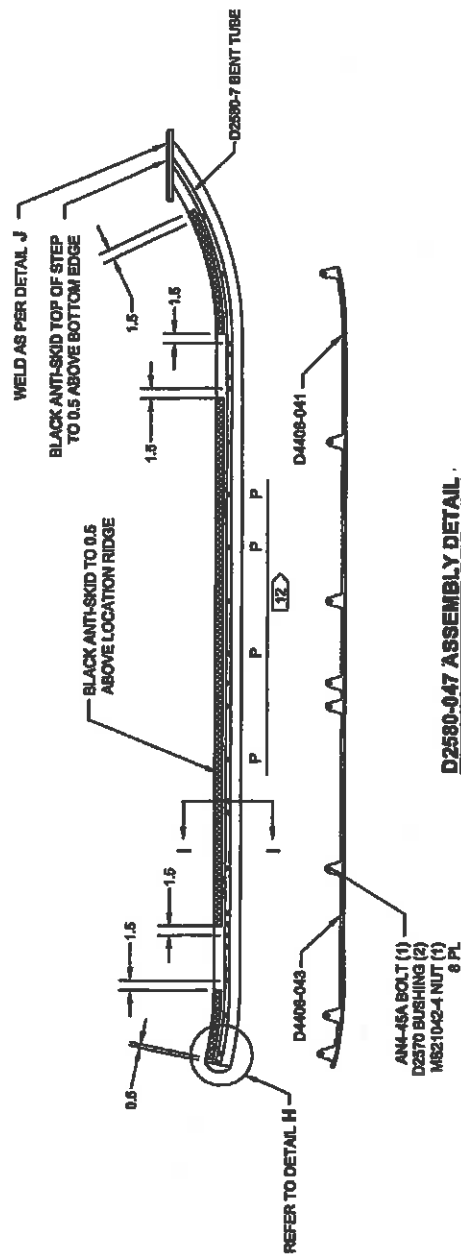
D2550-1 BENT TUBE
(MAKE FROM D2550-101 TUBE)

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2017 JUL 05 4

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	15	DRAWING NO. D2550
MPG APPR	15	REV. H SHEET 3 OF 9
APPROVED	15	TITLE 205 SKIDTUBE ASSEMBLY
DE APPR	15	SCALE NT8
DATE	17.06.09	COMPANY & REV BY DATE / APPROVAL LTD

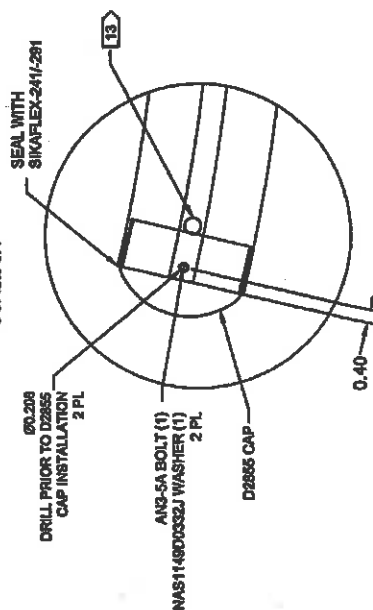
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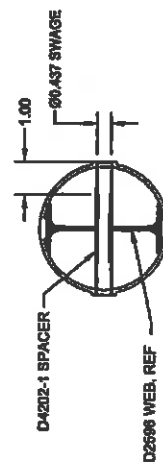


D2580-047 ASSEMBLY DETAIL

**DETAIL H
SCALE 5X**

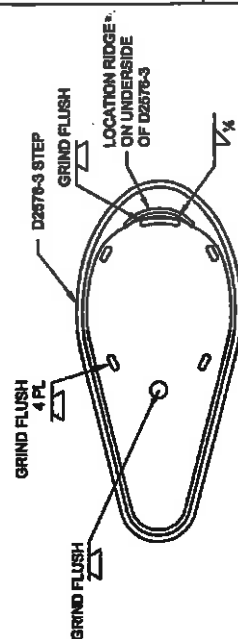


**SECTION H
SCALE 5X**



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER CSI 002
3. TRIM/GRIND FLUSH PER CSI 002

**DETAIL J
SCALE 5X**



DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED		REV. H
MFG. APPR.		DRAWING NO. D2580
APPROVED		SHEET 6 OF 6
DE APPR.		TITLE 205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE NTS

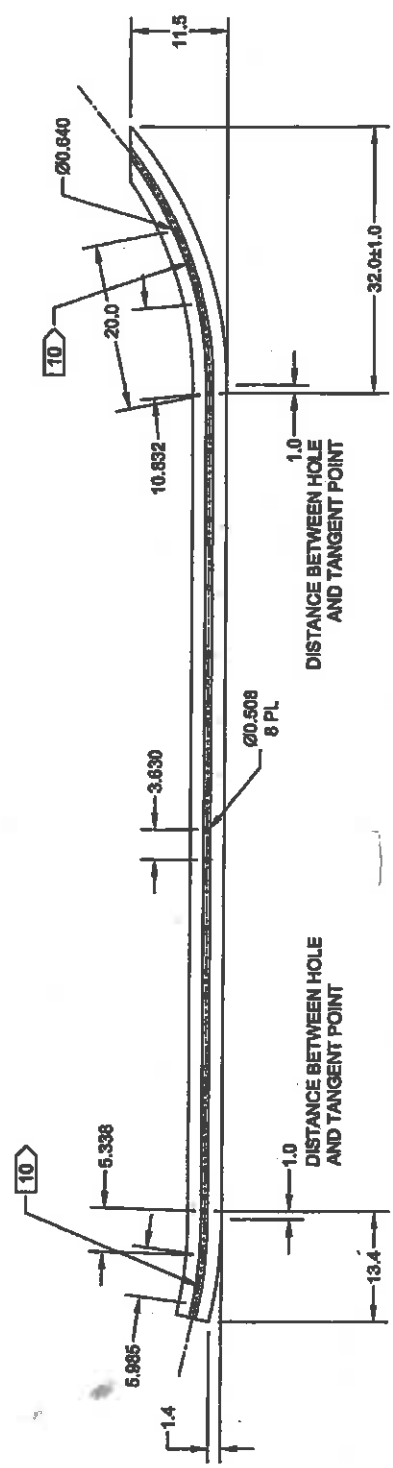
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D C B A

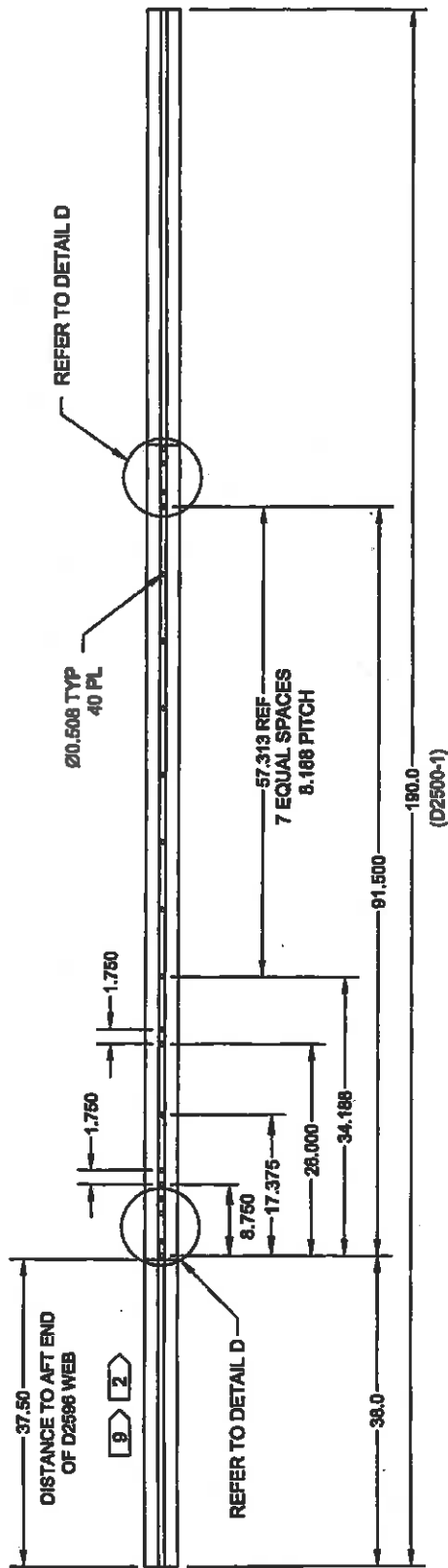


D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HARRISBURT, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D2580
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTS
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D2580-101 TUBE

DESIGN	CS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D2580 SHEET 9 OF 9
APPROVED		TITLE SCALE
DE APPR.		206 SKIDTUBE ASSEMBLY NTS
DATE	17.08.09	

RELEASED
2017 JUL 05

DETAIL D
SCALE 5X

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